

Date: Thursday, 05/02/2009 8:17:54 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE EXTRUSION
Job Number : 45501	
Estimate Number : 10047	
P.O. Number :	Part Number : D6203
This Issue : 05/02/2009 S.O. No. :	Drawing Number : D6203 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 31395	Material :
Written By :	Due Date : 12/02/2009 Qty: 20 Um: Each
Checked & Approved By : <u>C L09/02/05</u>	
Comment : Est. A: 01.05.16 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 8139

a) Description: Angle extrusion 1.500" x 1.500" x 0.125"

b) Material: 6061-T6/T651 (QQ-A-200/8)

c) Minimum ultimate tensile strength = 38 ksi

d) Minimum yield tensile strength = 35 ksi

C L09/02/05(20/4)

2.0	D6203P	Angle 6061T6 1.5x1.5x125
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**Comment:** Qty.: 1.0000 f(s)/Unit Total: 20.0000 f(s)

Angle 6061T6 1.5x1.5x125

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C L09/02/11 (20)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6203

09-02-13 20

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C L09/02/13 20/4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE EXTRUSION

Job Number: 45501

Part Number: D6203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

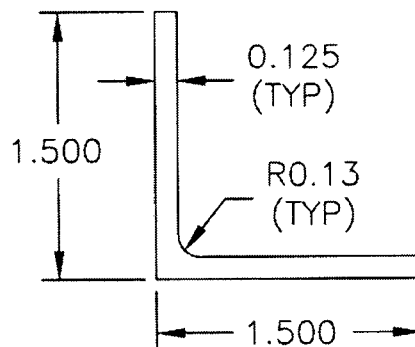
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D6203	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE ANGLE EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23



D6203-XXX ANGLE EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6203-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE
1.500" x 1.500" x 0.125"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45501

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DART

Purchase Order

Date Feb 05, 2009	Page 1
Purchase Order Number PO00008139	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
06/02/05

Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Feb 05, 2009	N30	yours	Feb 11, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
12.0000	M6061T6B0375X007	6061T6 BAR .375 x .750 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR PER AMS-QQ-A-225/8 OR AMS 417/4128/4115/4116 PER AMS-QQ-A-200/8 OR AMS 4160	11/02/2009	No	1.333333	f	16.00
40.0000	M6061T6B0375X010	6061T6 BAR .375 x 1.00 Comments: AS ABOVE	11/02/2009	No	1.050000	f	42.00
60.0000	M6061T6B1000X020	6061-T6 Bar 1.00 x 2.00 Comments: AS ABOVE	11/02/2009	No	5.500000	f	330.00
✓ 20.0000	D6203P ✓	Angle 6061T6 1.5x1.5x125 Comments: AS PER DWG D6203 REV. A MATERIAL: 6061-T6/T6511 (QQ-A-200/8) SIZE: 1.5" X 1.5" X 0.125" B45501	11/02/2009	No	1.000000	f	20.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Comments:**Tax Summary:**

GST 20.40
ONT PST 0.00

Less:
included tax

0.00

Subtotal

408.00

Total tax

20.40

Total purchase order in

CAD Dollars

428.40

Entered By: *CL* CLAVOIE

Approved By: *W*

Empire Resources, Inc.

One Parker Plaza
Fort Lee, NJ 07024-2937
United States
Tel : (201) 944-2200
Fax : (201) 944-2226
dfike@empireresources.com

ANALYSIS CERTIFICATE

EMPIRE Letter Ref # : EWR44431



Wednesday, 14 May, 2008

Date : May 14, 2008
Sales Contract # : E131500
Alloy-Temper : 6061-T6
Container # : EXTR20080414
Case # : EXC16721
Cast # : 729444
Die # : A10063
Specification : .125" X 1.5" X 20' ANGLE 6061, T6
Purchase Order : 073349-AD1
Customer Part # :

MADE IN THE USA

Chemical Composition (WT%)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other Elements	
Min	0.40		0.15		0.8	0.04			Each Max	Total Max
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Actual	= 0.54	= 0.18	= 0.19	< 0.01	= 0.8	= 0.07	= 0.02	< 0.01	= 0	

* Aluminum = Remainder

Actual cast analysis is retained on file.

Tensile Properties

Test No.	Yield (ksi)	Tensile (ksi)	Elong. (%)
1	37.5	39.8	14.2

ASTM B308/B308M-02. AMS QQ-A-200/8

Ross Toombs

Authorized Signature

Ross Toombs
General Manager

CH 349